

Work Order ID 164089

Thursday, July 13, 2017 11:48:44 AM

164089

Page 1

Item ID: D4306-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rib
 Start Date: 7/12/2017 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 7/20/2017 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 Date: JUL 13 2017 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4306	C								

100

0.00

100

Large Fab

Large Fab

Memo

2.10

- 1- Cut tube 50"
- 2- Bend tube with manuel pipe bender as per DT9567
- *** Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending***
- 3- Trim access tube material to finish size as per dwg D4306

6X D.M.L 2017-07-18
Dr

110

QC6- All purchased or subcontracted products

0.00

110

QC

Quality Control

Memo

0.00

6

DAS
38
9-89

JUL 18 2017

Work Order ID 164089

Thursday, July 13, 2017 11:48:44 AM

164089

Page 2

Item ID: D4306-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rib

Start Date: 7/12/2017 Start Qty: 6.00

6

Cust Item ID:

Required Date: 7/20/2017 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

Identify as per dwg & Stock Location: D.M.L

0.00

120

Packaging

Memo

0.06

Packaging

LOCATION: WA004

6x D.M.L 2017-07-20

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.60

Quality Control

DAS
21
9-89

JUL 20 2017

Picklist Print

Thursday, July 13, 2017 11:48:47 AM

Page 1

Work Order ID: 164089

164089

Parent Item: D4306-1

D4306-1

Parent Item Name: Rib

Start Date: 7/12/2017

Required Date: 7/20/2017

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 11.01.20 new issue DD verf:EC
11.03.03 AS PER DWG REV.C DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304TS0.750W.049

Purchased

No

100

f

938.6895

4.1666

26.31537

✓ *M304TS0 750W 049*

**

D.M.L 2017-07-18

304 SQ Tube .75x.75x.049W

Location

Loc Qty

Loc Code

WA004

938.689474

M137401

0.689474

M137625

482

M137824

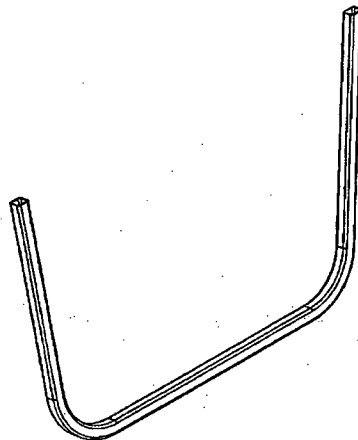
156

M137934

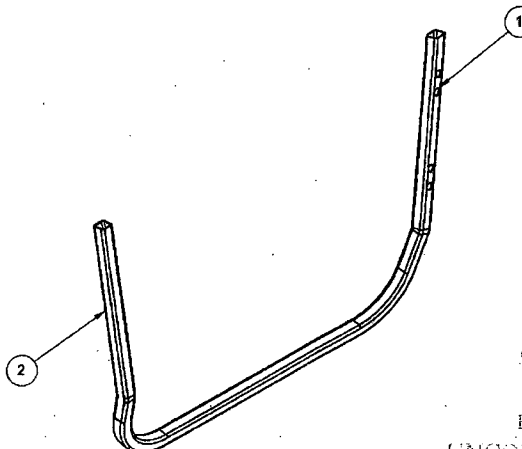
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27

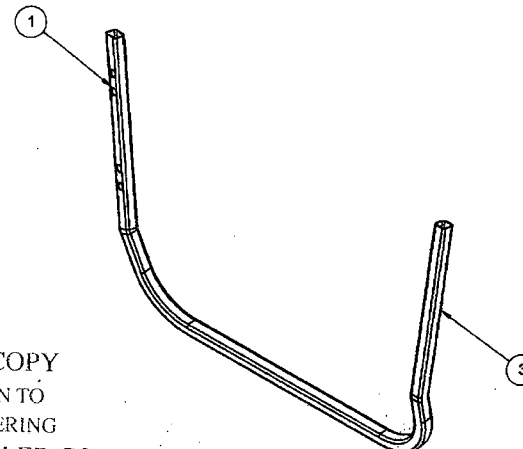
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	X			D4306-043	RIB ASSY, LH
		X		D4306-044	RIB ASSY, RH
			X	D4306-045	RIB ASSY
1	4	4	4	D3759-1	BUSHING
2	1			D4306-3	RIB
3		1		D4306-4	RIB
4			1	D4306-5	RIB



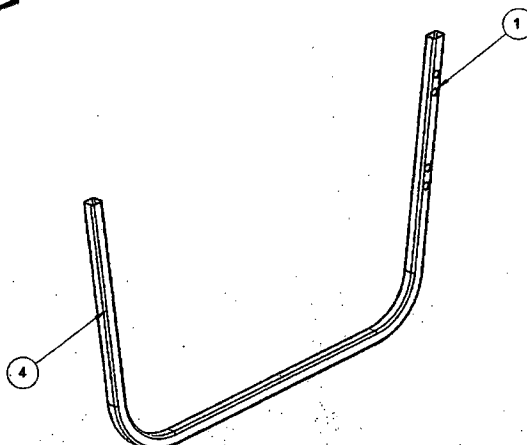
D4306-1 RIB



D4306-043 RIB ASSY, LH



D4306-044 RIB ASSY, RH



D4306-045 RIB ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 164089 MJS
1707-13

RELEASED
2011-03-10

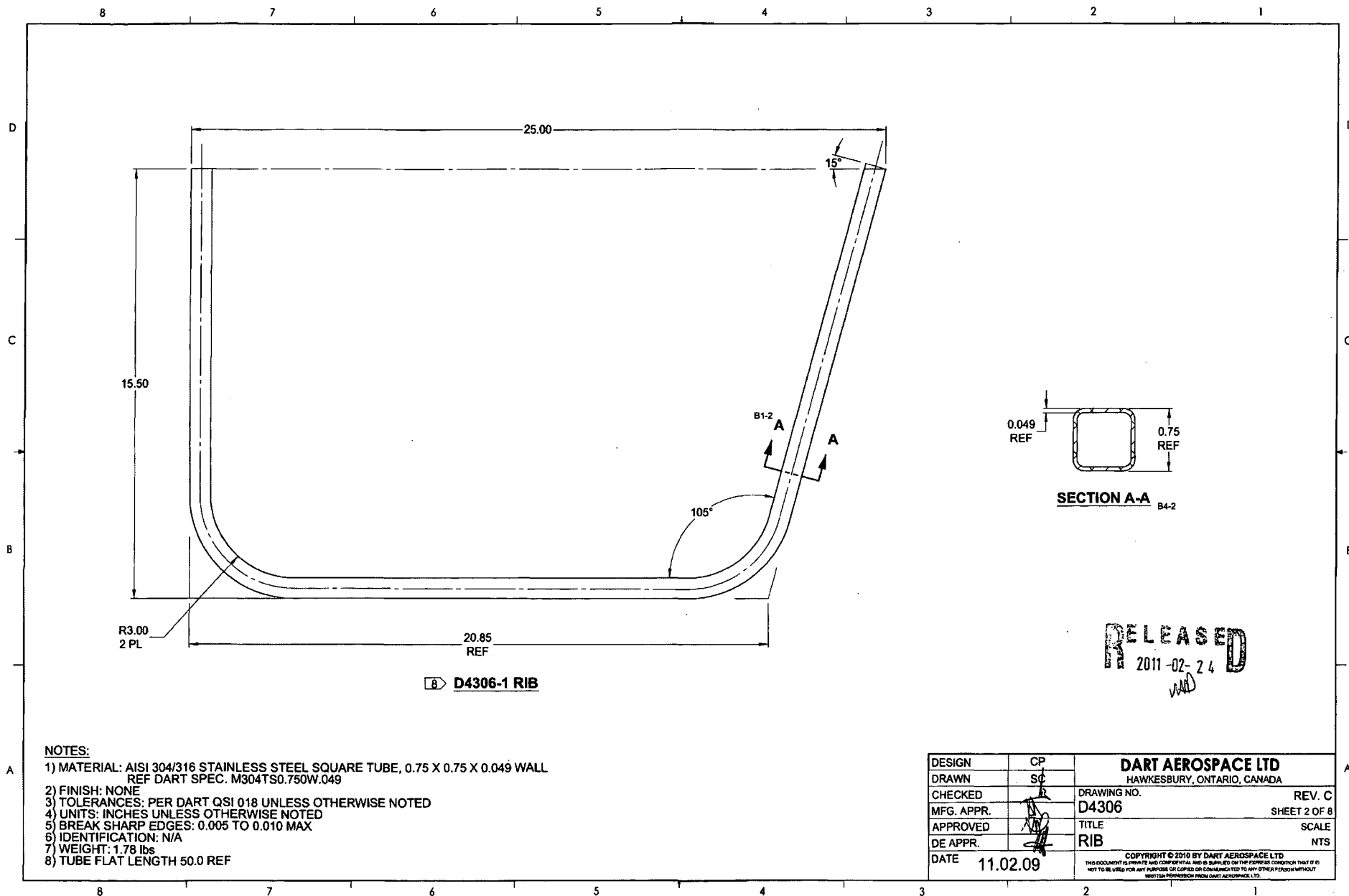
C	REFERENCE LENGTH CHANGED TO 52.0" FOR D4306-3, D4306-4 RIBS (A7-4/8); INCREASED LENGTH OF D4306-3, D4306-4 RIBS BY 0.65" (C7-4, C8-4, C1-6, C2-6); CHANGED CUT ANGLE FROM 19° TO 22° (B8-4, B1-6); ADDED 4.50" REF DIM ON D4306-043/044 (B6-3, B3-5)	SC	11.02.09
B	D4306-043, D4306-044, D4306-045 ADDED	SC	10.12.17
A	NEW ISSUE	CP	10.11.29
REV.	DESCRIPTION	BY	DATE
DESIGN	CP		
DRAWN	SC		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.02.09		

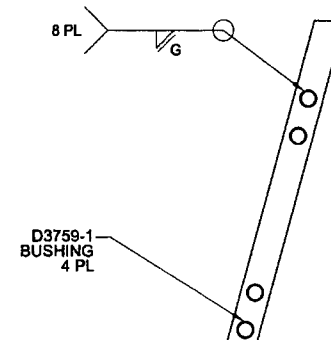
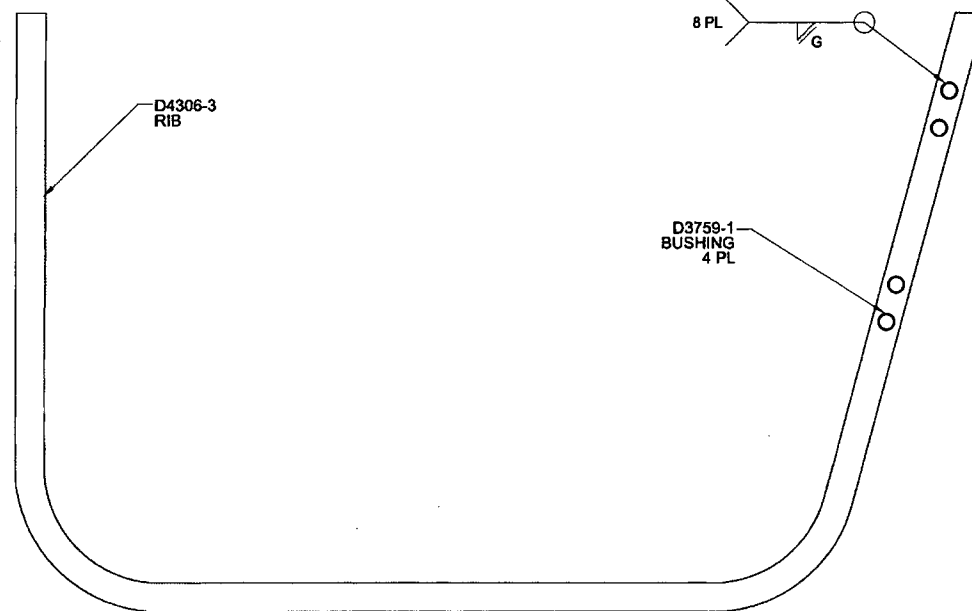
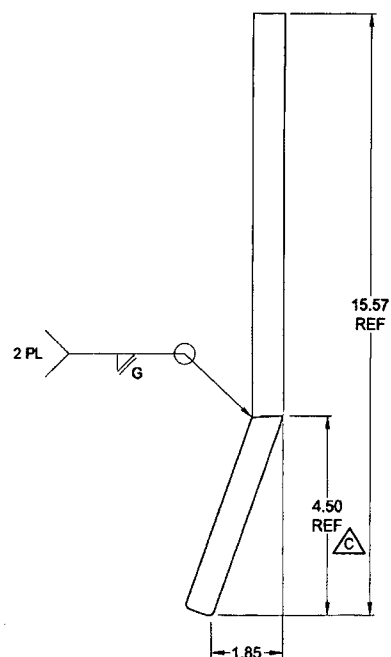
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4306 REV. C
SHEET 1 OF 8

TITLE RIB SCALE NTS

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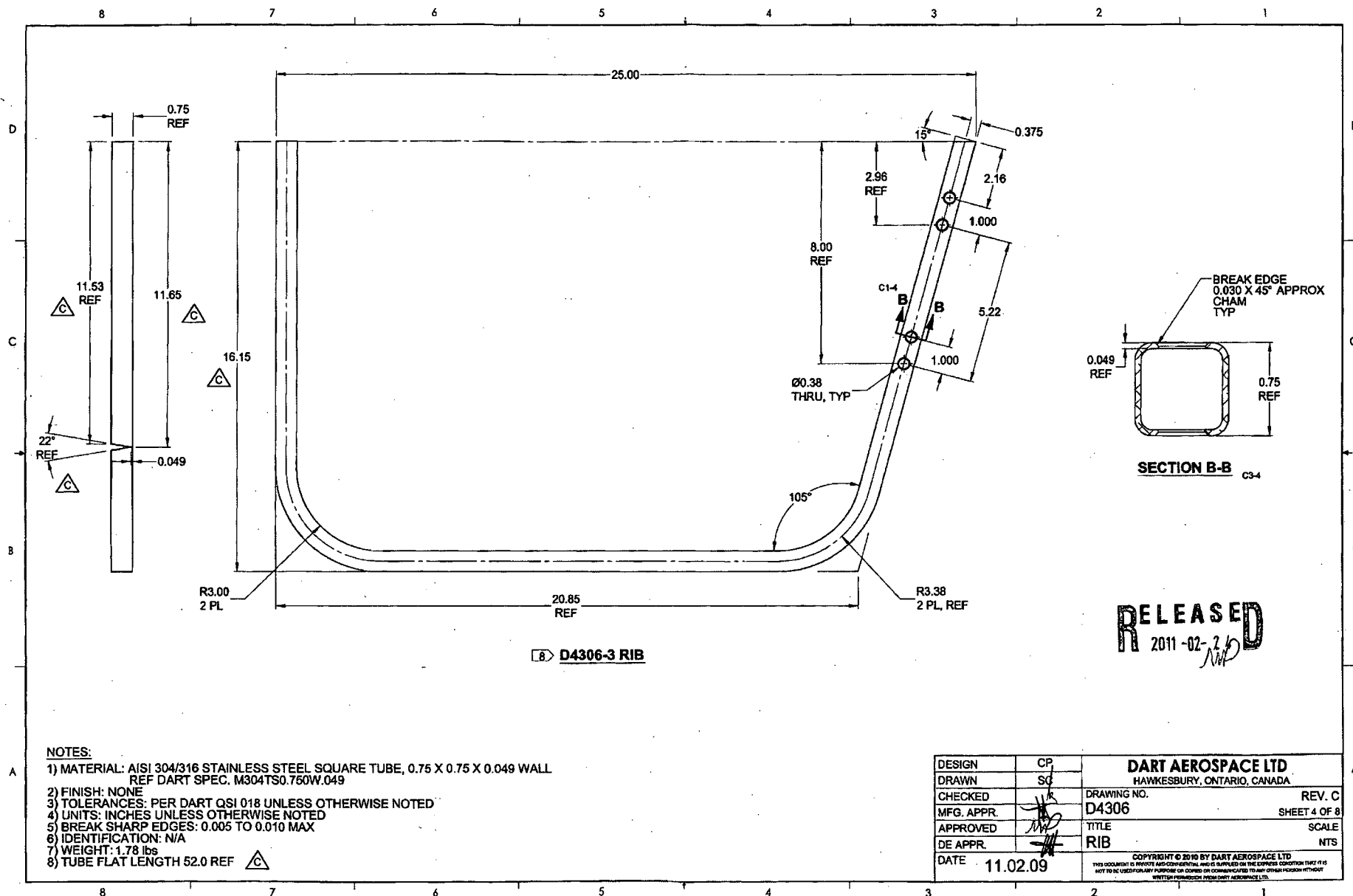
D4306-043 RIB ASSY, LH

RELEASED
2011-02-24

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) WELDING: PER DART QSI 004

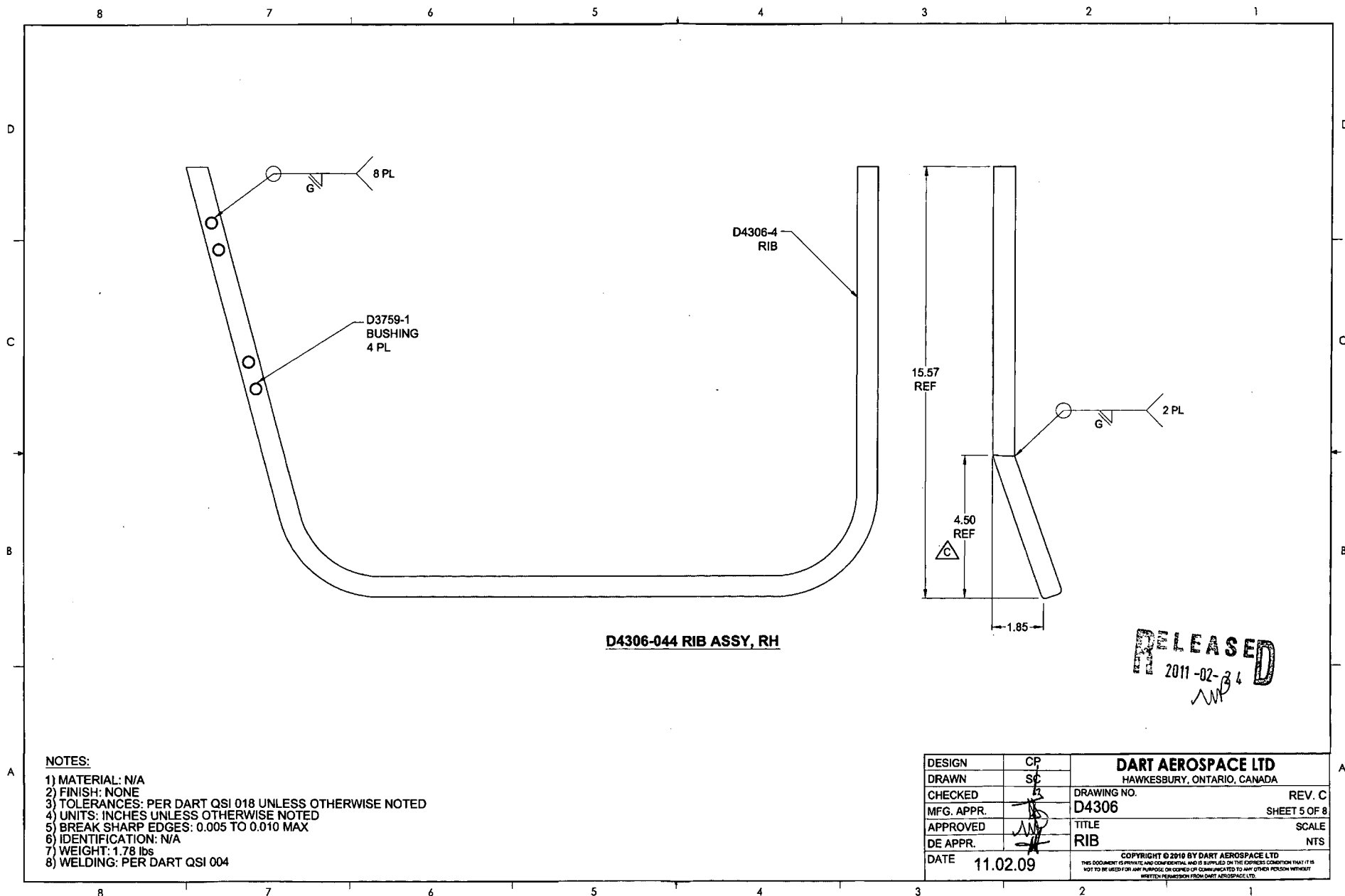
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NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) TUBE FLAT LENGTH 52.0 REF

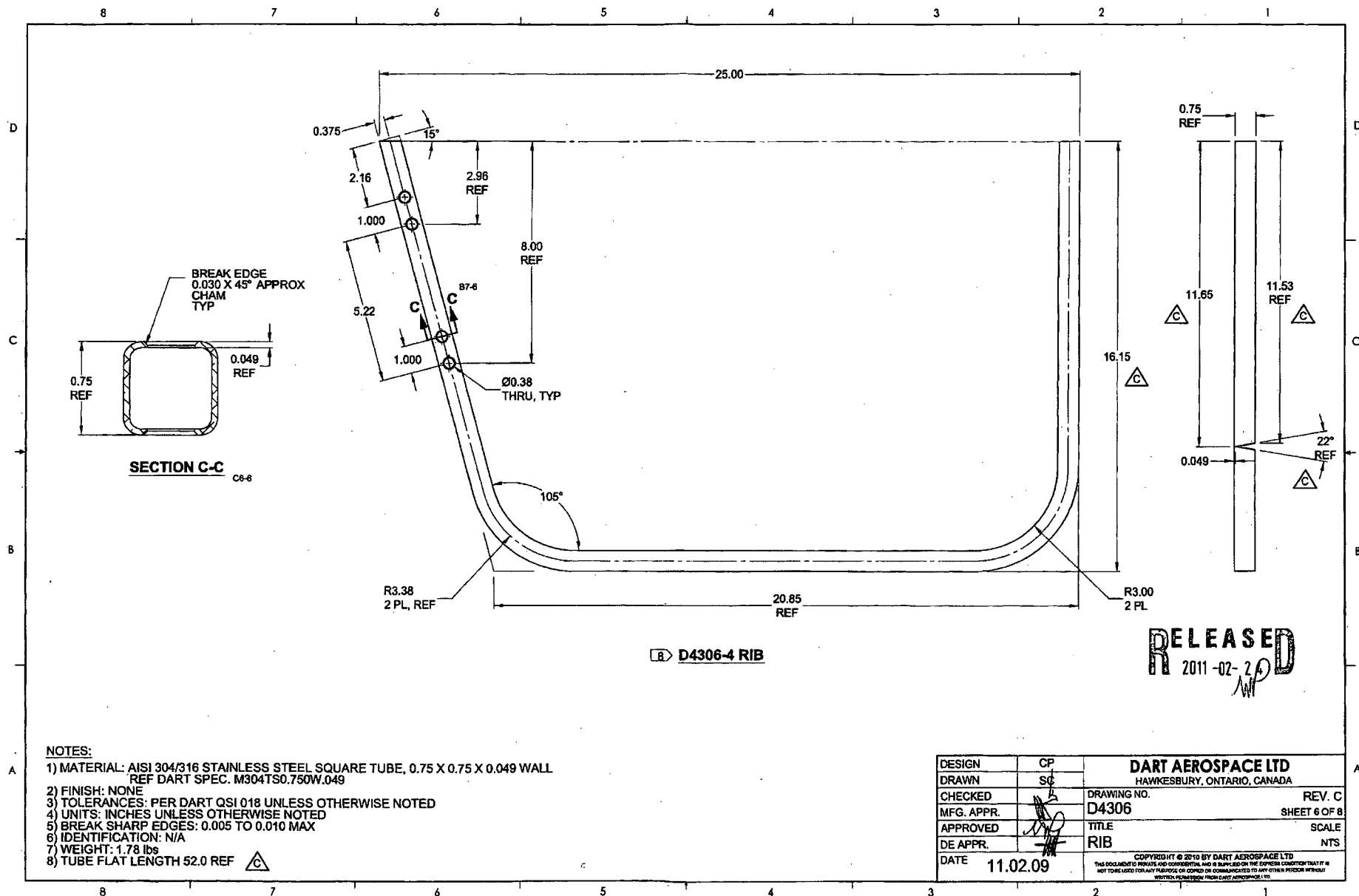
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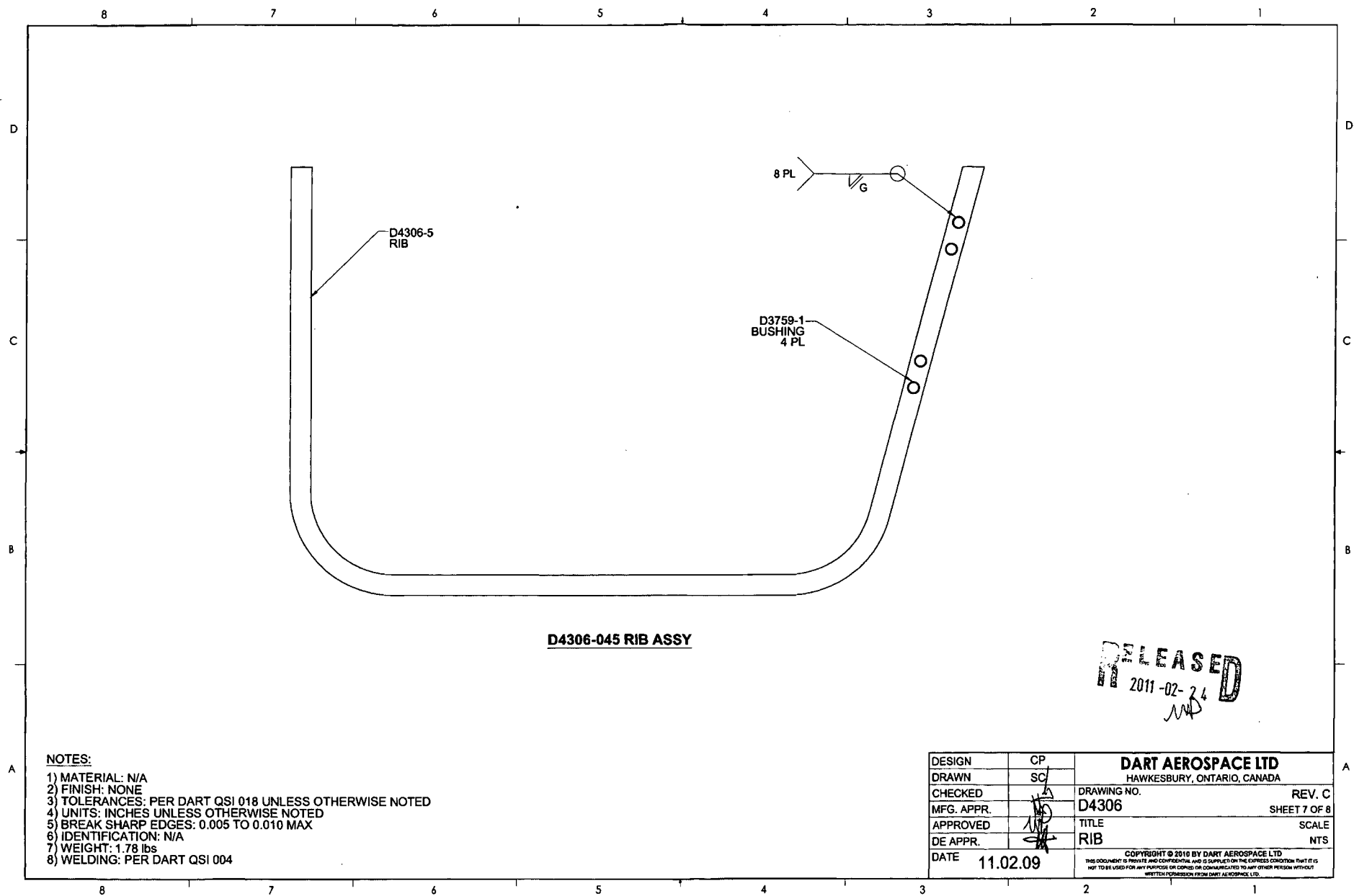


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 2011-02-24
MD

